

c2
c3
c4

crossover passage 48 is defined to provide a ball return to the helix passage 42. The drawn and coined eyelet 40 is designed to fit exactly with a duplicate drawn and coined eyelet 40 to trap the balls 44 between the two when positioned in flange-to-flange relationship with respect to one another. A temporary holding lock 52 can be provided to hold the eyelets 40 together during transfer to a molding machine. The assembled eyelets 40 are overmolded, to provide a solidly configured ball nut. Preferably, the eyelet 40 is manufactured from steel, such as UNS 610090, hardened to approximately 55 R_c to approximately 65 R_c and preferably to approximately 62 R_c and iron nitride hardened, or stainless steel, such as UNS 54000, spherodized, annealed and heat treated. The lock 52 can include one or more tabs 54 placed on the flange end 46 to temporarily hold the assembly together. A punch or diverter 56 may be provided to direct the balls 44 into the crossover passage 48.

In the claims:

8. (Amended) The ball nut of claim 1 further comprising:
a diverter extending with respect to the helix passage to direct ball
bearings into the crossover passage.

38. (Amended) In a ball nut having at least one internal bearing race with a first end and a second end, and a crossover passage for connecting the first end and the second end to form a continuous recirculating path for a plurality of ball bearings, the improvement comprising:

a ball nut body with at least one helix passage for receiving a plurality of ball bearings, a crossover passage formed to define an individual raceway for each helix passage, each raceway having a separate, single orbit, recirculating rotational path, the ball nut body having an elongate, generally cylindrical-shaped, metal injection molded body.

Please cancel claim 39 without prejudice.